

Work Order ID 61366

Thursday, August 19, 2010 1:58:12 PM



Page 1

Item ID: D3281-4L08

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft RH

Stop



Start Date: 8/19/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 10-08-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3281	DEO E-1

100



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

MF 10/08/24

105



Dry Material

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240 F

Time IN: 5:40 pm 10/08/24




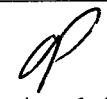

Time OUT: 7: am 10/08/25

MF 10/08/25

PTO →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3281-4L08 PAR #: _____ Fault Category: Eng-Drawing NCR: Yes ☒ No ☐ DQA: 7 Date: 10.09.01
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>61366</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.08.27	130	PARTS NARROWER THAN DWG BY $2 \frac{1}{8}$ "	 10.08.27 AS/UYL	- DWG ERROR. - DWG DATA DIMS NEED UPDATING. - Acceptable	 10/08/01	 10/08/30	 10.08.27 AS/UYL	 10/08/30
				SEE CAR 10-21				

NOTE: Date & initial all entries

Work Order ID 61366

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Item ID: D3281-4L08

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Setup Start

Revision ID:

Stop

Item Name: Floor Protector, Aft RH

Start Date: 8/19/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D3281 and Folio FTA 010 Dwg. Rev. <u>E</u> Folio Rev. <u>D</u>	0.00 0.00				<u>13</u>		<u>10/08/25</u>	
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>13</u>		<u>10/08/25</u>	
130  Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00				<u>13</u>		<u>10/08/25</u>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61366

Thursday, August 19, 2010 1:58:12 PM



Page 3

Item ID: D3281-4L08

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft RH

Stop



Start Date: 8/19/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
160 Packaging Packaging	Packaging Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61366

Thursday, August 19, 2010 1:58:12 PM

Page 4



Item ID: D3281-4L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH

Start Date: 8/19/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/31 *[Signature]*
CL10/8/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 19, 2010 1:58:11 PM

Page 1

Work Order ID: 61366



Parent Item: D3281-4L08



Parent Item Name: Floor Protector, Aft RH

Start Date: 8/19/2010

Required Date: 8/25/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No				sf	2,563.470	5	15.78947			

Lexan Sheet

Location

therm

113127

Loc Qty

2563.47

2563.47

Loc Code

15 sq ft. 14. 10/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Floor Protector, Aft RH		Part Number:	D3281-4
Inspection Dwg: D3281	Rev: <i>DE DL</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	<i>✓</i>			
Shape Definition	<i>✓</i>			
Texture Retention	<i>✓</i>			
Material imperfections such as bumps, cracks, voids, scratching	<i>✓</i>			

Measured by: *DL* Date: *10/08/25*

TRIMMING SECTION

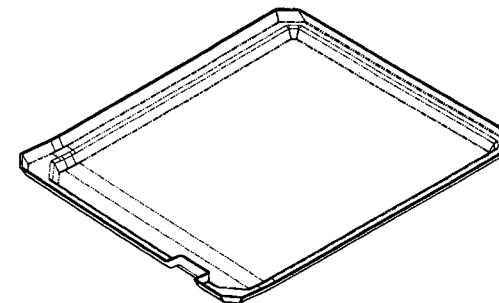
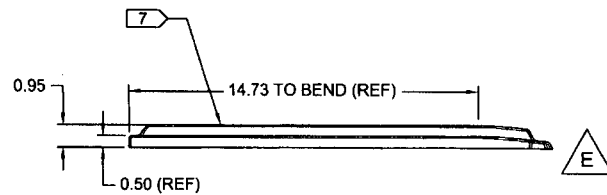
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	<i>17.05"</i>	<i>✓</i>			<i>SEE JCR Pg 1</i>
17.1	+/-0.100	<i>17.065"</i>	<i>✓</i>			
14.3	+/-0.100	<i>14.25"</i>	<i>✓</i>			
0.95	+/-0.030	<i>0.975"</i>	<i>✓</i>			
0.25	+/-0.030	N/A				
3.1	+/-0.100	N/A				
0.050	Min	<i>0.060"</i>	<i>✓</i>			
0.070	Min	<i>0.084"</i>	<i>✓</i>			

Measured by: *DL* Date: *10/08/25*
 Audited by: *JB* Date: *10/08/2027*
 Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	<i>DL</i>
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <i>DL</i>	<i>DL</i>

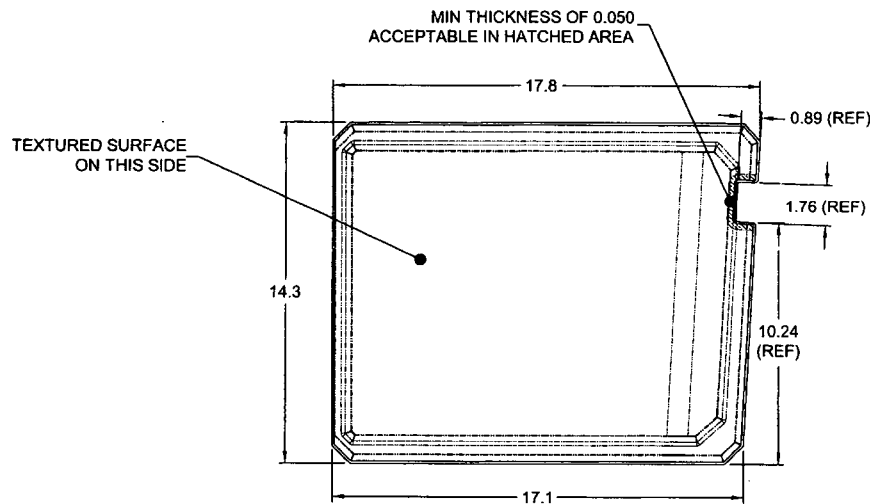
8 7 6 5 4 3 2 1

D



61360

C



B

D3281-4 FLOOR PROTECTOR

DEO ATTACHED

RELEASED

2010-02-03

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D3281 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		FLOOR PROTECTOR NTS
DATE	10.01.05	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>K</i>	MFG. APPR. <i>DL</i>	APPROVED <i>HL</i>		DE APPR. <i>HL</i>		
DATE 10.02.24	DATE 10.02.25	DATE 10/02/25	DATE 10.02.25		DATE 10.02.25		

PURPOSE

ADD "D3281-xL08" MATERIAL OPTION. EXISTING PARTS TO BE IDENTIFIED AS "D3281-xL02"

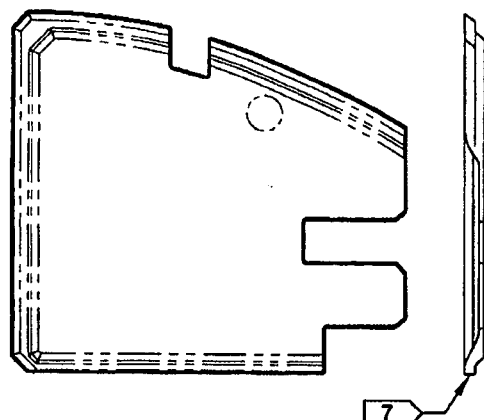
CHANGE

D3281-xL08 PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS EXCEPT AS DETAIL BELOW. THE MATERIAL, IDENTIFICATION, AND WEIGHT NOTES ARE AMENDED AS FOLLOWS:

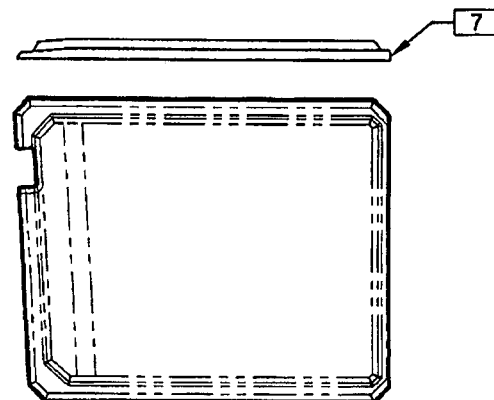
- 2) MATERIAL: -xL02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
 -xL08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xLxx" AND B/N "Bxxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.
 FOR -xL08 PARTS, LOCATE ENGRAVING ALONG PERIMETER OF PART AS SHOWN.

- 8) WEIGHT: D3281-1L02/-2L02 = 0.95 lb D3281-1L08/-2L08 = 1.13 lb
 D3281-1L02/-2L02 = 0.87 lb D3281-3L08/-4L08 = 1.05 lb



D3281-1L08 FLOOR PROTECTOR (SHOWN)
D3281-2L08 FLOOR PRETECTOR (OPPOSITE)
 LOCATION OF ENGRAVING



D3281-3L08 FLOOR PROTECTOR (SHOWN)
D3281-4L08 FLOOR PRETECTOR (OPPOSITE)
 LOCATION OF ENGRAVING

RELEASED
 2010-02-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries